PRELIMINARY ISSUE

Work	Order	ID	641	62



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Thursday, Nover	nber 25, 2010	0 4:02:19 Pi	М		! UBE!B \$4141 21						:	. Tugo I
Item ID: Revision ID: Item Name: Start Date: Required Date:	D4298-006 PRELIM Machined Inne 11/25/2010 12/3/2010	er Assembly Start Qty: Req'd Qty		13 14 15 15 15 15 15 15 15	Accept	Cust Item II			Serve scale	Setup Star		
Reference:				(100141 1181 1881								
Approvals:	Process Pla	n:	Ñ/	Date: <u> 6- -20</u>	Tooling: SPC (Y/N):	Da	te:		R	Run Star Sto		
Sequence ID/ Work Center II)	Operation Description	1		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D4298	PA1											
Bandsaw Jeaspa Bandsaw		N	1 emo		0.00 0.00	Riolial 07				16		
HAAS CNC vertical	machine #1		lemo		0.00 COO	P 10/12/07				B	<u>.</u>	
110 QC			parts off ma	achine FAI/FAIB	0.00	2 10/12/07				&		
Quality Control		1▼	ivino						Sky.		,	

	-								•					
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date: _						
	Re	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date: _						
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NCI	R)								
DATE	CTED	Description of NC		Corrective Action Secti		Verifi	cation	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Chief Eng	QC Inspector					
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		t contract the contract to the	i 1		1	1		1	1					

Work Order ID 64162

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Page 2

Item ID:

D4298-006

PRELIM

Revision 'D: Item Name:

Machined Inner Assembly

Start Date:

11/25/2010

Start Qty: 1.00

Accept



Setup Start

Stop



Cust Item ID: Req'd Qty: 1.00 Required Date: 12/3/2010 **Customer:**

Reference:

Approvals:

Process Plan:

QC:

Date: Date:

Tooling: SPC (Y/N):

Date:

Date:

Start Run



Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours**

0.00 - inspecto to Ena

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> M 10/12/08

Memo

į 140

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

Oven Temperature:

0.00

0.00

1 16/10/29.

Finish Time:

	1	 = =							_
W/O:			W	ORK ORDER CHANGE	S				,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCF	R)			
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 64162

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Item ID:

D4298-006

PRELIM

Revision ID: Item Name:

Machined Inner Assembly

Start Date:

11/25/2010

Start Qty: 1.00

Required Date: 12/3/2010 Req'd Qty: 1.00



Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Start Run

Stop



Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

10/12/09

Tool ID

Qty Code

Reject Accept Qty

Reject Number

Insp. Stamp

160

Small Fab

Small Fab

Memo

1- Assemble as per dwg

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

0.00

Memo

170

Quality Control

0.00

	-									_
W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE	-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate		NCF	l: Yes	No DQ	A:	Date: _	
	Re	șolution:	Disposition	n:	QA:	N/C CIG	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 64162

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Insp.

Stamp

Item ID:

D4298-006

PRELIM

Pevision ID: Item Name:

Machined Inner Assembly

Start Date:

11/25/2010

Start Qty: 1.00

Required Date: 12/3/2010

Req'd Qty: 1.00



Customer:

Cust Item ID:

Date:

Date:

Tool # Plan

Code

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

Accept

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Run

Accept

Qty

Start

Reject

Qty

Stop

Setup Start

Stop

Number

Reject

Sequence ID/ Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:_____

Memo

0.00

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

POSITIVE RECALL

EFFECTIVE 10.11-29 AUTH

RELEASED ____

DATE

	•								
W/O:			WO	ORK ORDER CHANG	GES				,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
D.4.T.F.	0755	Description of NC			ction B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
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	1					1			

Thursday, November 25, 2010 4:02:23 PM

Work Order ID: 64162

Oluci ID. 04102

Parent Item:

D4298-006

Parent Item Name: Machine Inner Assembly



Start Date. 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

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IPP revA 10.11.24 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.00		Purchased	No			100	f	40.0000	0.28	0.294737			
5 5061-T6 Bar .750 x 1.00										لل	1/11/0	7	
				Location		Loc C	<u> Dty</u>	Loc Code					
				MAT02	12567		40 40		_	-30			
4298-024		Manufactured	No			160	Each	0.0000	1	1			
errated Adjustment Washer					В	64144				_SB	10/12	115	
/IS20426AD3-# 6 		Purchased	No			160	Each	5,984.000		1		-	
IVET [2]	5			Location		Loc Q	<u> Dty</u>	Loc Code					
					04374 10398	1	984 984 000		_				
	,					Mi	05059	5		/	So	18/1	2/13

	•									
W/O:			WO	RK ORDER CHAN	GES					•
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	gory:	NCF	R: Yes	No DQ	A:	Date:	·
	R	esolution:	Disposition	ı:	QA:	N/C Cid	sed:		Date: _	
NCR:			WORK ORD	R NON-CONFORM	IANCE	(NCR)			
D.47F	OTED	Description of NC			ection B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date		ion C	Chief Eng	QC Inspector
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	•	D/24/1/2
DART AEROSPACE LTD	Work Order:	D1/21/2 1/12
· ·		
Description: INNER	Part Number:	D4248-008
Inspection Dwg: DY298 Rev: A ERA -OF		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.21	±,03b	3.208	_		Vern	ML-7
2.83	±.036	2.834			10	ė
.88	±-030	.877			10	٠,
1.52	± 030	1.520			٠,	· c
-39	±036	387			ار	۸,
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.060	±.01b	.060			٠,	٠, ٠
.47	±.030	.472	_			'1
.2011	'±-030	2.108			1.6	q
73	±.03b	727			14	U
.23	+ 030	284			/(٠,
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		4				
	·					

Measured by:	' 'E ~	Audited by:	2	Preliminary App	rovai:
Date:	10/12/07	Date:	1		Date:

R	ev Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



